

W Set

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907

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DAS
21
9-88

RBEM622U3001101-7
Job Sheet 181885



2-S #38
9-2

1/1

9-15

Part No: RBEM622U3001101-7

Job Qty: 6 ea

Part Name: Base Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/10/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM622U3001101 Rev. 2 IPP Rev. A 18.06.26 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Waterjet		DC 18/08/23
100	Waterjet	6 pcs	8/20/18	8/20/18	0.00	0.60	Waterjet 2 OMAX		DC 18/08/23
120	Mori Seiki	6 pcs	8/20/18	8/20/18	0.00	6.00	MORI NV5000-2		7/18/10/09
130	QC	6 pcs	8/20/18	8/20/18	0.00	0.00	QC2-2		18-10-09
140	QC	6 pcs	8/20/18	8/20/18	0.00	0.00	QC8		18-10-09
170	Outsource	6 pcs	8/20/18	8/20/18	0.00	0.00	Outsource12	OCT 09 2018	18-10-09
180	Packaging	6 pcs	8/20/18	8/20/18	0.00	0.00	Packaging2		18-10-09
190	QC	6 pcs	8/20/18	8/20/18	0.00	0.00	QC6		18-10-09
200	Packaging	6 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-1		18-10-09
210	QC21-SA	6 Ea	8/20/18	8/20/18	0.00	0.00	QC21		18-10-09

Part Op 100 - 1-Cut blank as per DWG.(REB BARN folder). DWG. Rev: 2 PROG. Rev: 2 Debur if necessary
Descriptions: 120 - 1-Machine as per folio FC273 FOLIO REV: DWG REV: 2-Debur 3-Fixture is on shelf A

170 - -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500X10.000	AISI 4140 Steel Sheet/Plate	3.3000 ft (.55 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-0.500X10.000	3	11	0

Part Specifications

Specifications could not be found.

Plex 8/22/18 4:20 PM dart.logan.david



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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 81C 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S104531



Part: RBEM622U3001101-7

Job No: 181885

Serial No/Batch: S104531

Revision: 2

Inspector:

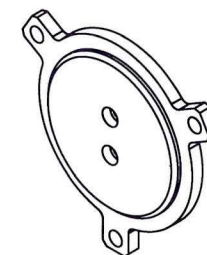
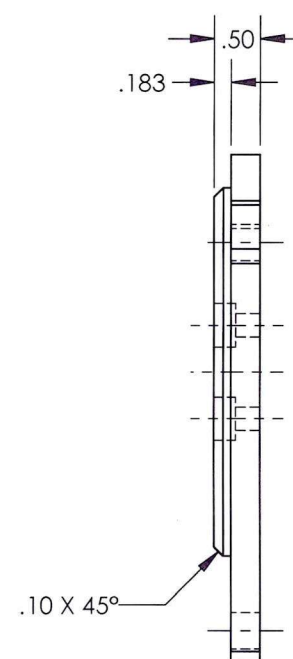
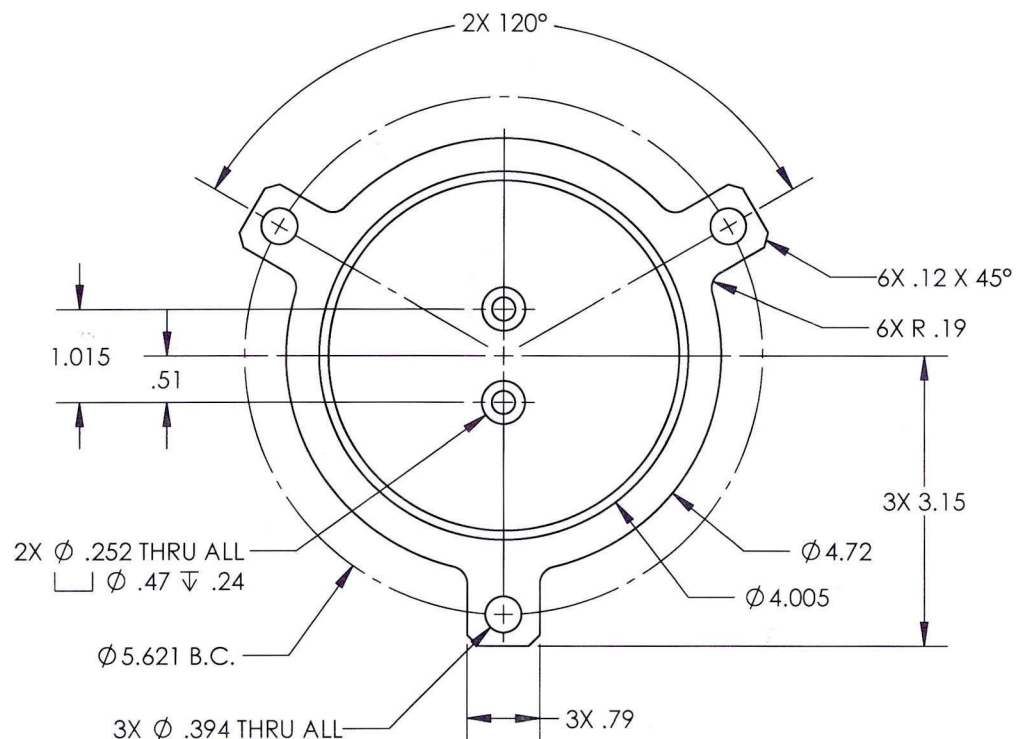
Exp Date:

Instructions:

Date: 08/23/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0172	-7 CH'D FINISH WAS QMSI-6.2.2, REV D IS QSMI-6.2.2, B.O. REV D, CH'D MATERIAL WAS 1018/1020 CR IS 4140/4142, ADDED HEAT TREAT RC 28-32.	10/14/2016	RJC	SM



(-7)
BASE PLATE

DART AEROSPACE	
TITLE CONICAL EXTRACTOR	
DWG NO. RBEM622U3001101-7	REV 2
MAT'L 4140/4142 HEAT TREAT RC 28-32 FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT CHECKED: MACKOVJAK OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL H175	
SCALE 1:2	DATE 4/15/2016 SHEET 5 OF 11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Tel (613) 632-5200

E-MAILED
OCT 10 2018

Via:	Ground
Pymt Terms:	Net 60
Freight Terms:	
Special Comments:	

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181885	RBEM622U3001101-7	Base Plate -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	10/17/18	1 pcs	0 pcs	1 pcs	\$120.00/pcs	\$120.00
Grand Total:											\$120.00





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PURCHASE ORDER PO041280

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

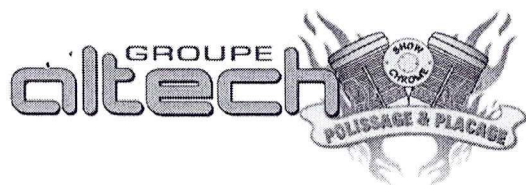
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/10/18 12:55 PM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(013367-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013367 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Oct-2018		Aman		041280				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM622U3001101-7 Rev.	RBEM622U3001101-7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	1	1	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.